

5/03

DART AEROSPACE LTD		Work Order:	22054
Description: Doubler 04.11.25		Part Number:	D3302-1
Dwg: D3302 Rev. AB B1 RF 04.12.15		Qty:	10
		Page 1 of 1	

04.12.15

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler Note: To be made in multiples of 10	04	04.12.08	10
2	MV	Cut blank: 12.900" x 7.850" 13.150" Material: 6061-T6 (QQ-A-250/11) 0.063" thick (M6061T6S.063) Identify for D3302-1 Batch: M16455	CPL	05-01-17	10
3	MV	Machine as per Folio FA450 and Dwg D3302 Stack of 10 Identify as D3302-1	Er	05-01-18	10
4	QC2	Inspect parts as they come off the CNC machine	Er	05-01-18	10
5	QC8	Second check	04	05-01-31	10
6	GA	Deburr break all unmarked sharp edges 0.005 to 0.010	2	05-02-14	10
7	GB	Form as per Dwg D3302	2	05-02-14	10
8	QC5	Inspect work to Step 7	04	05-01-22	10
9	FP	Chemical Conversion Coat as per QSI 005 4.1	04	05-02-20	10
10	QC3	Inspect Chemical Conversion Coat	ML	05-02-28	10
11	ST	Identify and Stock	CL	05/03/01	10
12	AC	Cost / part 17.61	Sgc	05-03-02	10
13	DC	Close W/O 16.55 Inspect Level 21	04	05.03.02	10

Rev	Date	Change
A	04.09.02	New issue

Revised By	Approved
JLM	

RELEASED
11/04/09





W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

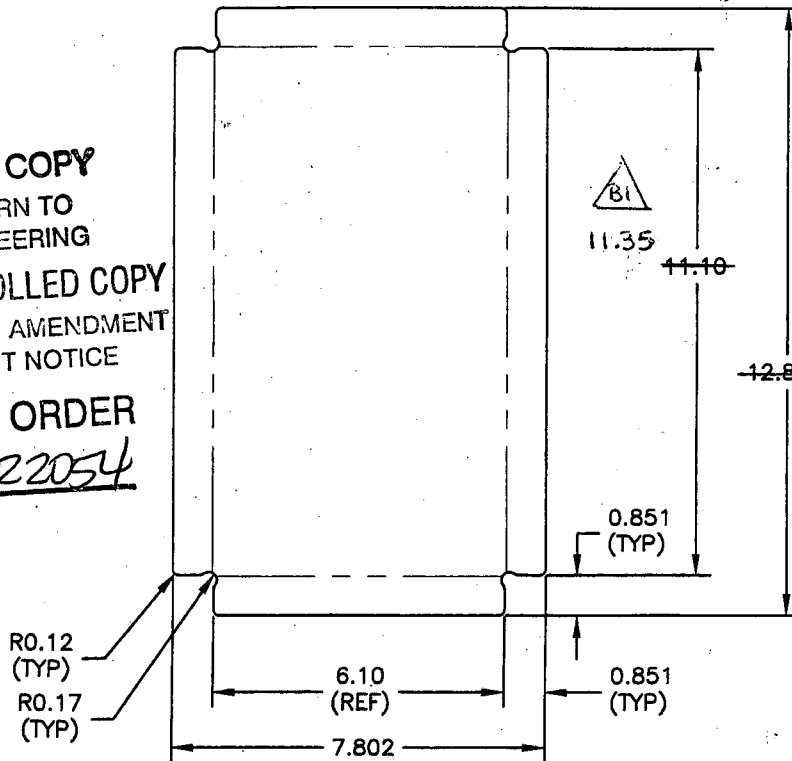
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

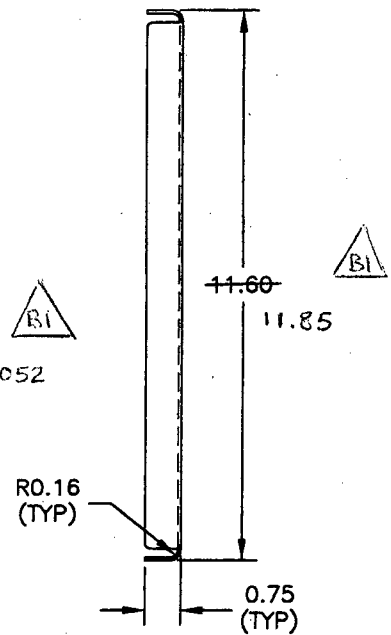
DESIGN 		DRAWN BY 		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 		APPROVED 		DRAWING NO. REV. B D3302 SHEET 1 OF 4	
DATE 04.11.18		TITLE SCALE DOUBLER 1:4			
A	04.07.06		NEW ISSUE		
B	04.11.18		REMOVE HOLES		
B1	RF 04.12.15		ADDED 0.25" TO THE LENGTH		

RELEASED
04.11.23

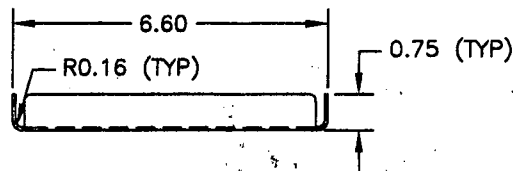
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WORK ORDER
NO. 22054



D3302-1 FLAT PATTERN



**D3302-1 DOUBLER
BEND - DETAIL**



PRELIMINARY ISSUE

D3302-1 NOTES:

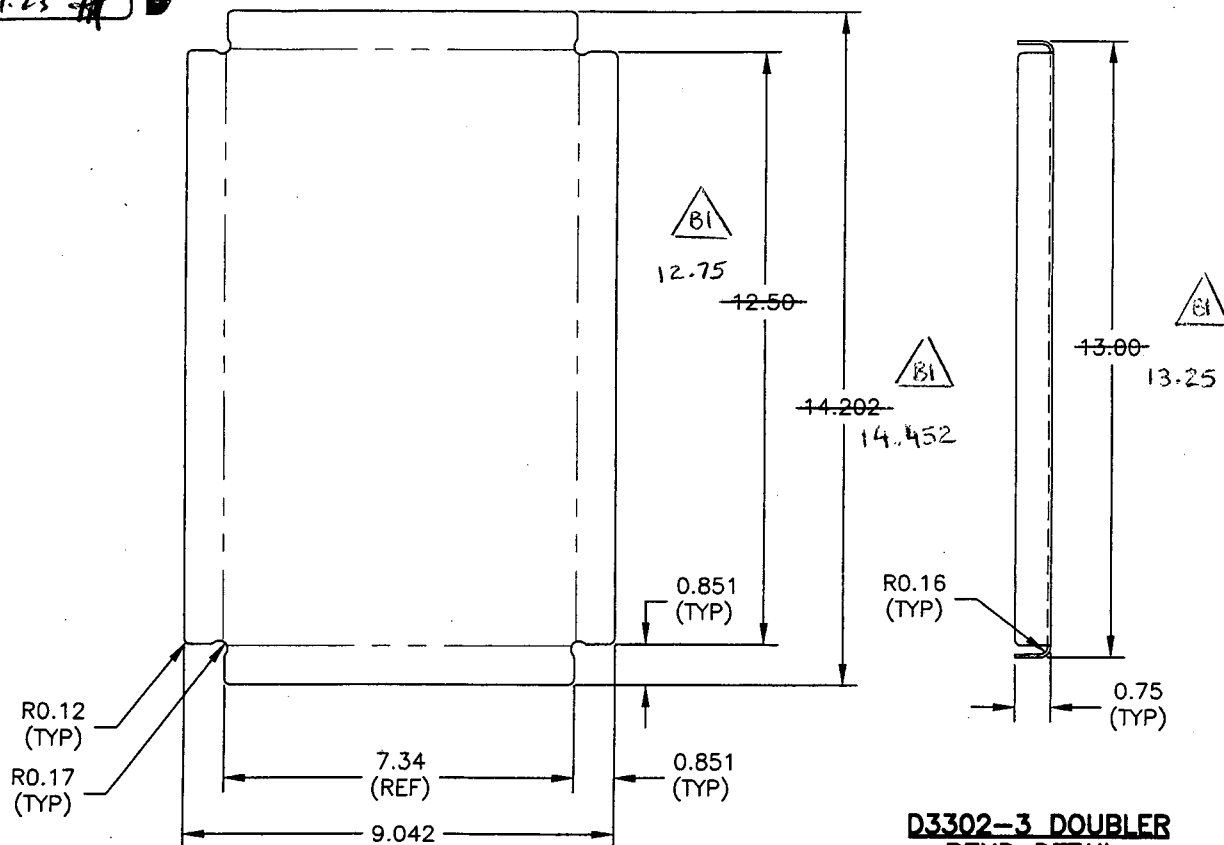
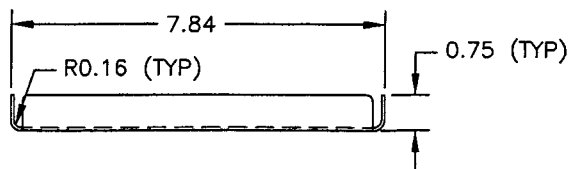
- 1) MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK. (REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

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DART

DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3302	REV. B SHEET 2 OF 4
DATE 04.11.18		TITLE DOUBLER	SCALE 1:4

RELEASED
04.11.23 #**PRELIMINARY ISSUE****D3302-3 FLAT PATTERN****D3302-3 DOUBLER
BEND DETAIL****SHOP COPY**RETURN TO
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WITHOUT NOTICE**WORK ORDER**NO. 22054**D3302-3 NOTES:**

- 1) MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & BATCH USING FINE POINT PERMANENT MARKER

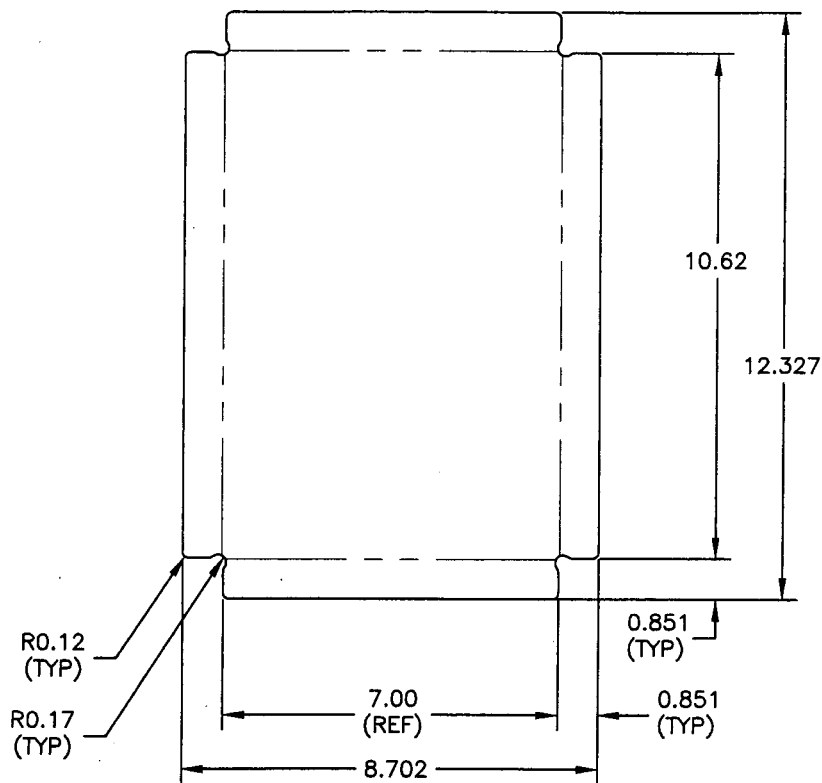
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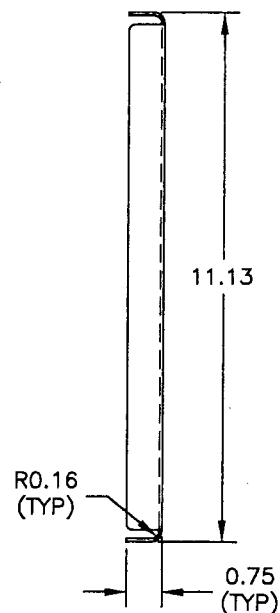


DESIGN RT	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3302	REV. B SHEET 3 OF 4
DATE 04.11.08		TITLE DOUBLER	SCALE 1:4

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04.11.23 [Signature]



D3302-5 FLAT PATTERN



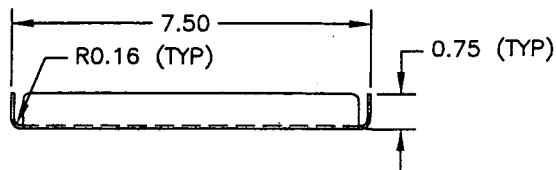
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WITHOUT NOTICE

WORK ORDER

NO. 22054



D3302-5 NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

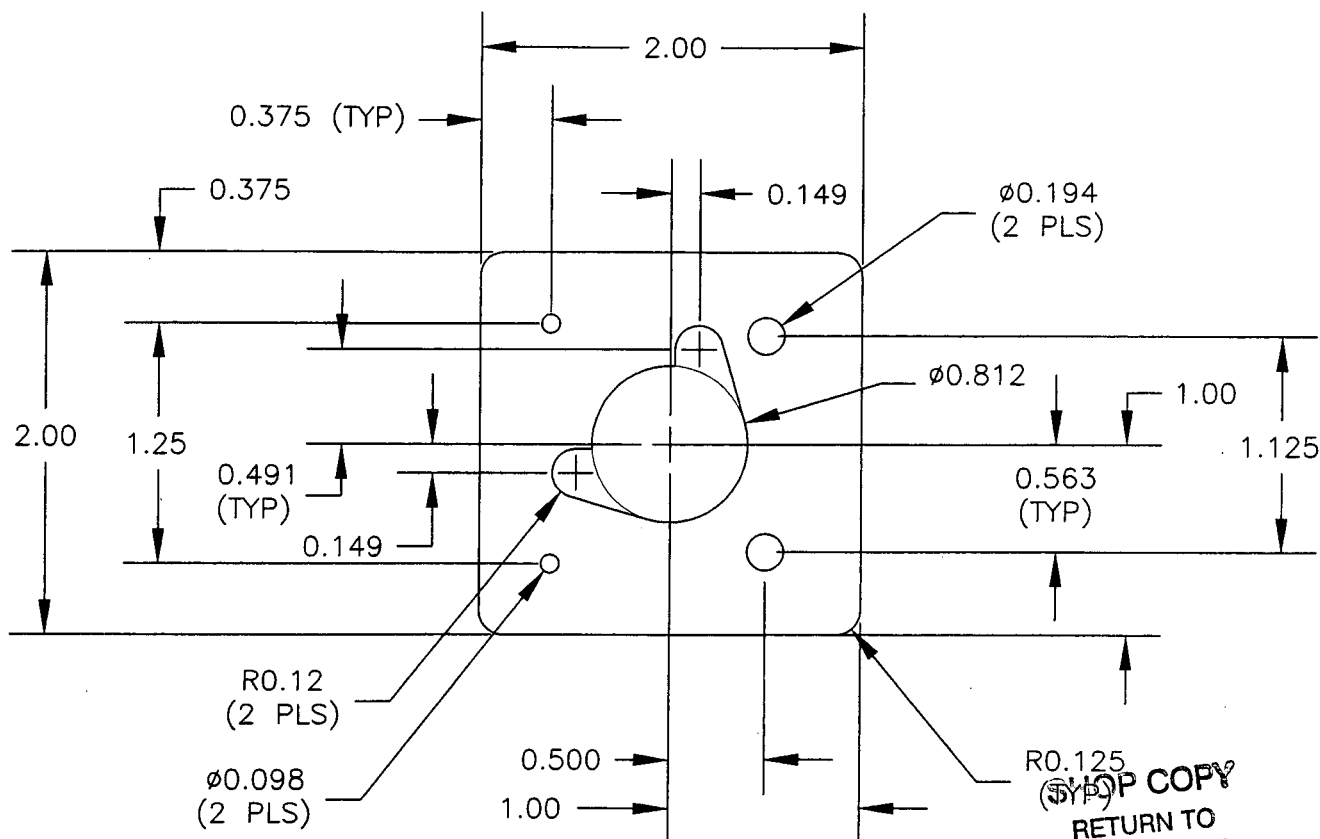
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3302	REV. B SHEET 4 OF 4
DATE 04.11.18	TITLE DOUBLER		SCALE 1:1

RELEASED
04.11.23



D3302-7

D3302-7 NOTES:

- 1) MATERIAL: 5052-H32 OR 6061-T6 (QQ-A-250/8 OR QQ-A-250/11)
0.040 THICK (REF. DART SPEC. M5052H32S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Dec 06, 2004
11:09 am

Work Order No : 0022054
Project Name : D3302-1
Project For : WK503
Work Order Type : Main
Main WO Number :
House Part Number : D3302-1
Description : Doubler
Manufactured : Yes
Amount Req'd : 10
Amount Done : 0
Start Date : 12-03-04
Est Finish Date : 01-15-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00